

# CIMPERIAL® 60CFF

Formaldehyde releasing biocide free cutting fluid for  
medium to heavy-duty applications



## Description

Cimperial 60CFF is a formaldehyde releasing biocide free, water miscible, semi-synthetic cutting fluid concentrate.

## Application

Cimperial 60CFF is a general-purpose, medium to heavy-duty cutting fluid developed for difficult machining, blanking and drawing operations on ferrous and non-ferrous metals. Cimperial 60CFF can be used for use in individual machines and central systems.

## Features and benefits

- Developed for a wide range of machining applications.
- Contains no formaldehyde releasing biocides.
- Special extreme pressure (EP) additives reduce tool wear.
- Especially suitable for use on tools with low clearance angles.
- Permits higher feeds and speeds and is recommended for operations where tool life and finish are important.
- Good rust control. Long fluid life due to the special product composition.
- Excellent emulsion stability (even under adverse conditions).
- Suitable as a replacement for cutting oils in automatics and multi-spindle machines where machine design permits the use of water based fluids.
- A clean, mild product which will not smoke or burn.
- Excellent residue characteristics.
- Can be used in water up to 10 - 20° dH.

## Methods of application

Cimperial 60CFF is easy to mix, normal stirring only. For automatic mixing, the use of the Cimcool® Mix Master or Cimcool Mix Master S is recommended. Typical starting water temperature conditions should be 5 - 25°C.

## Recommended starting concentration

Grinding & machining	4 - 8 %
Blanking, drawing	10 %

## Mix Master S

Concentration\*\* can easily be obtained by setting the regulator to the correct number.

\*\* The concentration may vary depending on local conditions. It is therefore always advised to check using the refractometer or TA Kit.

## Concentration analysis

For concentration analysis, use one of the below given methods or an appropriate laboratory procedure available from your local stockist.

Refractometer factor:	1.7
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If the refractometer is used, the resultant reading multiplied by a factor of 1.7 will only be relevant when applied to a fresh mix.

Cimcool TA kit	Use 2 ml. mix								*: next syringe	
%	1	2	3	4	5	6	7	8	9	10
Reading	0.81	0.70	0.59	0.47	0.36	0.24	0.13	0.02	*.90	*.79

## Handling and storage

Protect from freezing, direct sun and store between 5 - 35°C.

## Packaging type

5, 25, 200 and 1000 litre.

## Safety Data Sheet

The Safety Data Sheet should be consulted for specific information and information on Health, Safety and Environment when handling this product.



**Cimcool Industrial Products**  
Schiedamsedijk 20  
3134 KK Vlaardingen  
The Netherlands  
Tel: +31 (0)10-4600660  
cimcool.eu@duboischemicals.com  
[www.cimcool.com](http://www.cimcool.com)

